

Date: Tuesday, 7/18/2006 3:00:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 27967	
Estimate Number : 10498	
P.O. Number : N/A	Part Number : D2739
This Issue : 7/18/2006 S.O. No. : N/A	Drawing Number : D2739 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 27861	Material : N/A
Written By : [Signature]	Due Date : 8/5/2006
Checked & Approved By : [Signature]	Qty: 5 Um: Each
Comment : Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web B24410 : RT 06-08-18 (10)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739. RT 06-08-18 (10)

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 RT 06-08-18 (10)

3-Use uni-bit to open holes to finish size as per Dwg D2739. RT 06-08-21 (10)

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. RT 06-08-22 (10)

5-Deburr RT 06-08-22 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 06-08-22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 27967

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BT 06-08-22 (10)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PM 06-08-22 (10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location:

Y6 cell

BT 06-08-22 (10)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.24

Job Completion



06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

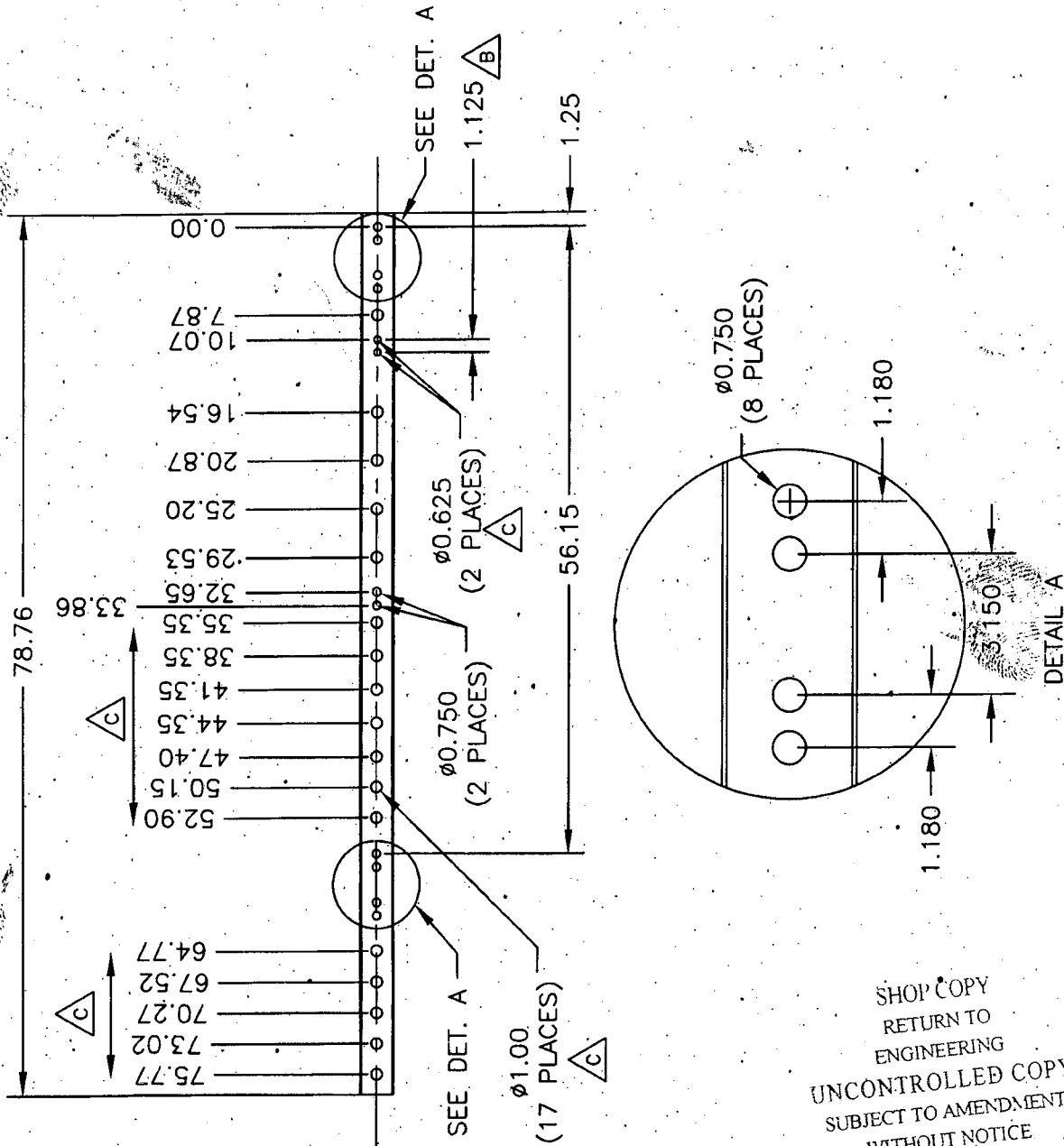
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
06-02-07

DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27967

D2739 WEB

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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